

Work Order ID 72044



Page 1

Monday, July 18, 2011 12:58:34 PM

Item ID:	D3684-047	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	FWD LEG ASS'Y					
Start Date:	7/18/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	7/25/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	7-18-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3684	Rev D								

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class I, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684								
	2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684								
	**Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3684								

SB 4/6/11

SB 4/6/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3684-047

Accept



Setup Start



Revision ID:

Stop



Item Name: FWD LEG ASS'Y

Start Date: 7/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/07/19

②

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

w/o
7/19/98

8/11/07/19 ②

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/20 HJ

ME
11-07-19

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Picklist Print

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Work Order ID: 72044

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y



Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A Bolts		Purchased	No			110	Each	40.0000	2	8			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST351</div> <div>40</div> <div></div> </div>													
<div> <div>117514</div> <div>4</div> <div></div> </div>													
<div> <div>118112</div> <div>36</div> <div></div> </div>													
D3688-1 STUD		Manufactured	No			110	Each	2.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>GA</div> <div>2</div> <div></div> </div>													
<div> <div>59668</div> <div>2</div> <div></div> </div>													
D3689-1 SLEEVE		Manufactured	No			110	Each	0.0000	1	4			
<div> <div>B70 358</div> <div></div> <div></div> </div>													
D3691-1 STUD		Manufactured	No			110	Each	14.0000	1	4			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>GA</div> <div>14</div> <div></div> </div>													
<div> <div>61370</div> <div>3</div> <div></div> </div>													
<div> <div>62181</div> <div>11</div> <div></div> </div>													

SB 11/07/19

SD 11/07/19

2 SB 11/07/19

SD 11/07/19

2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 72044

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

D3692-1 Manufactured No 110 Each 131.0000 4 16


SPACER



SS 11/07/19

Location Loc Qty Loc Code

ST075 131
51467 131

3

D3693-1 Manufactured No 110 Each 12.0000 1 4


Rod End Bearing



SS 11/07/19

Location Loc Qty Loc Code

GA 12
50734 12

2

MS21043-3 Purchased No 110 Each 808.0000 2 8


Nut



SS 11/07/19

Location Loc Qty Loc Code

FG 72
103691 72
ST301 736
112314 65
118077 671

4

NAS509-12C Purchased No 110 Each 18.0000 1 4


Nuts



SS 11/07/19

Location Loc Qty Loc Code

ST280 18
112453 18

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: FWD LEG ASS'Y

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 4.00

Required Qty: 4.00

NAS509L12C

Purchased

No

110

Each

23.0000

1

4



SB 6/18/11

Nuts

Location

Loc Qty

Loc Code

ST280

23

112314

13

112828

10

2

Dart Aerospace Ltd

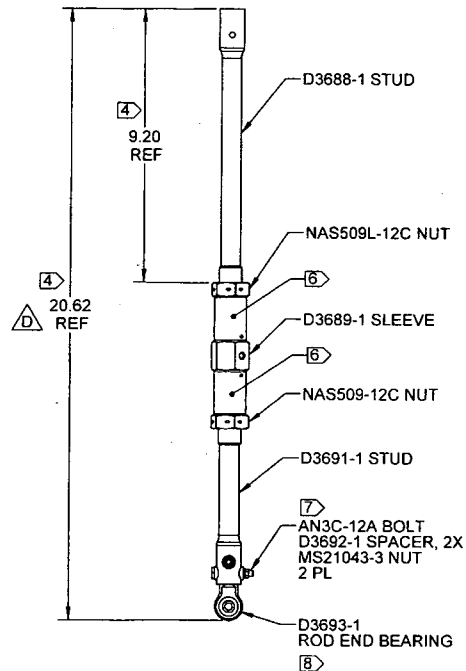
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12044
11-0718



RELEASED
2010-03-15
JWP

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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